

DUPLICATE

Dart Aerospace Ltd.

Date: Friday, 28/11/2008 10:43:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Job Number : 43705 Estimate Number : 11261 P.O. Number : This Issue : 28/11/2008 S.O. No. : Prsht Rev. : NC First Issue : 24/11/2008 Type : MACHINED PARTS Previous Run : 37432 Written By : Checked & Approved By : Comment : Est 05.09.13 New issue KJ/JLM	Drawing Name : LUG Part Number : D34143 Drawing Number : D3414 Project Number : N/A Drawing Revision : A Material : Due Date : 05/12/2008 Qty: 24 Um: Each
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Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B0500X2500	304 BAR .500 x 2.50
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Comment: Qty.: 0.1969 f(s)/Unit Total: 4.7250 f(s)
 304 BAR
 Material: 304/316 SS Bar
 (M304B0.500x02.500)
 Identify for D3414-3
 Batch: M18929

N.A 08/12/06

24

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.50" x 0.500" x 2.250" long

N.A 08/12/06

24

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA569 and Dwg D3414
 Identify as D3414-3Dwg Rev A Folio Rev A

N.A 08/12/06

24

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 08/12/06

24

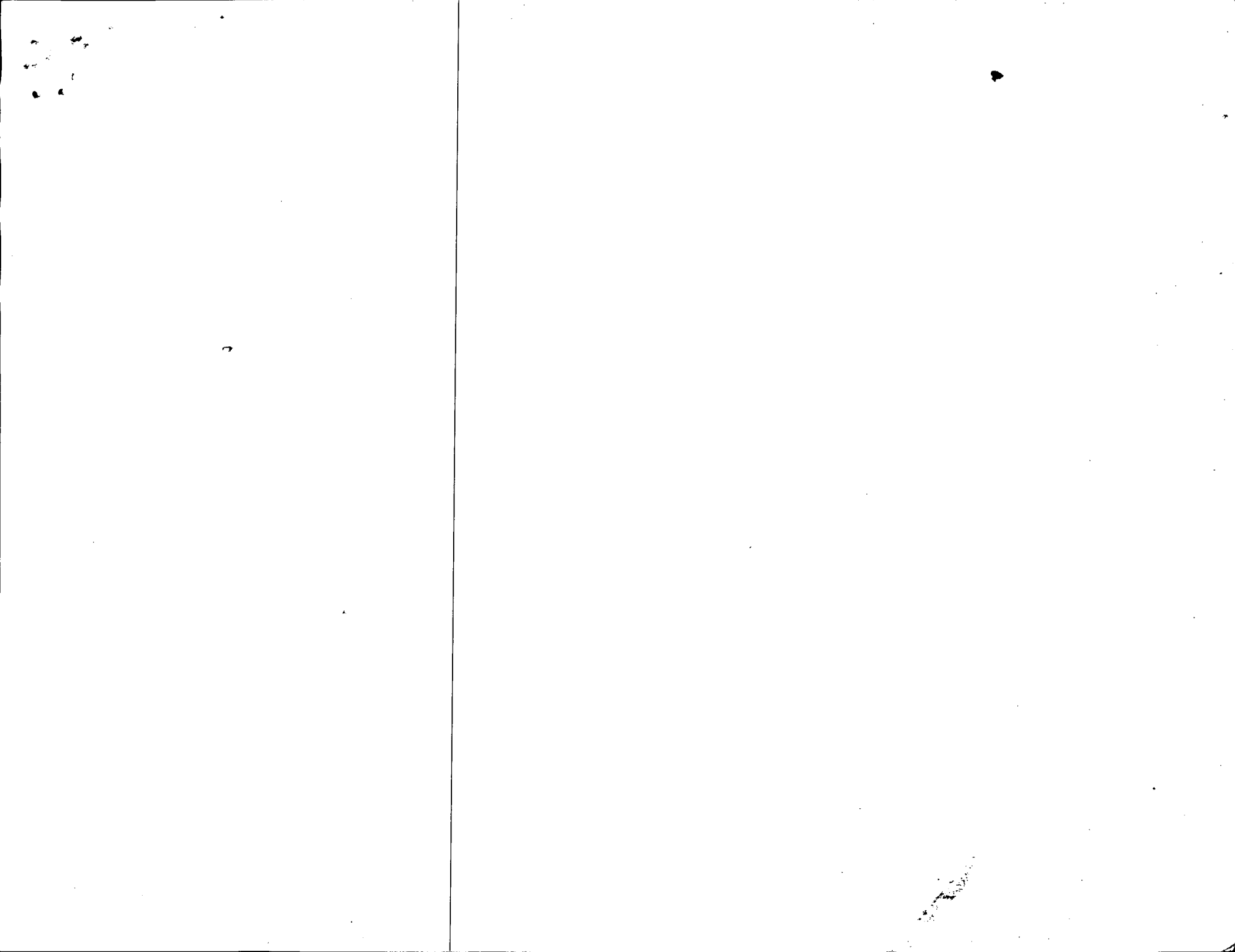
5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

DTP 08/12/07

24



Date: Friday, 28/11/2008 10:43:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 43705

Part Number: D34143

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

can be 8/12/08 24

7.0

QC21

FINAL INSPECTION/W/O RELEASE



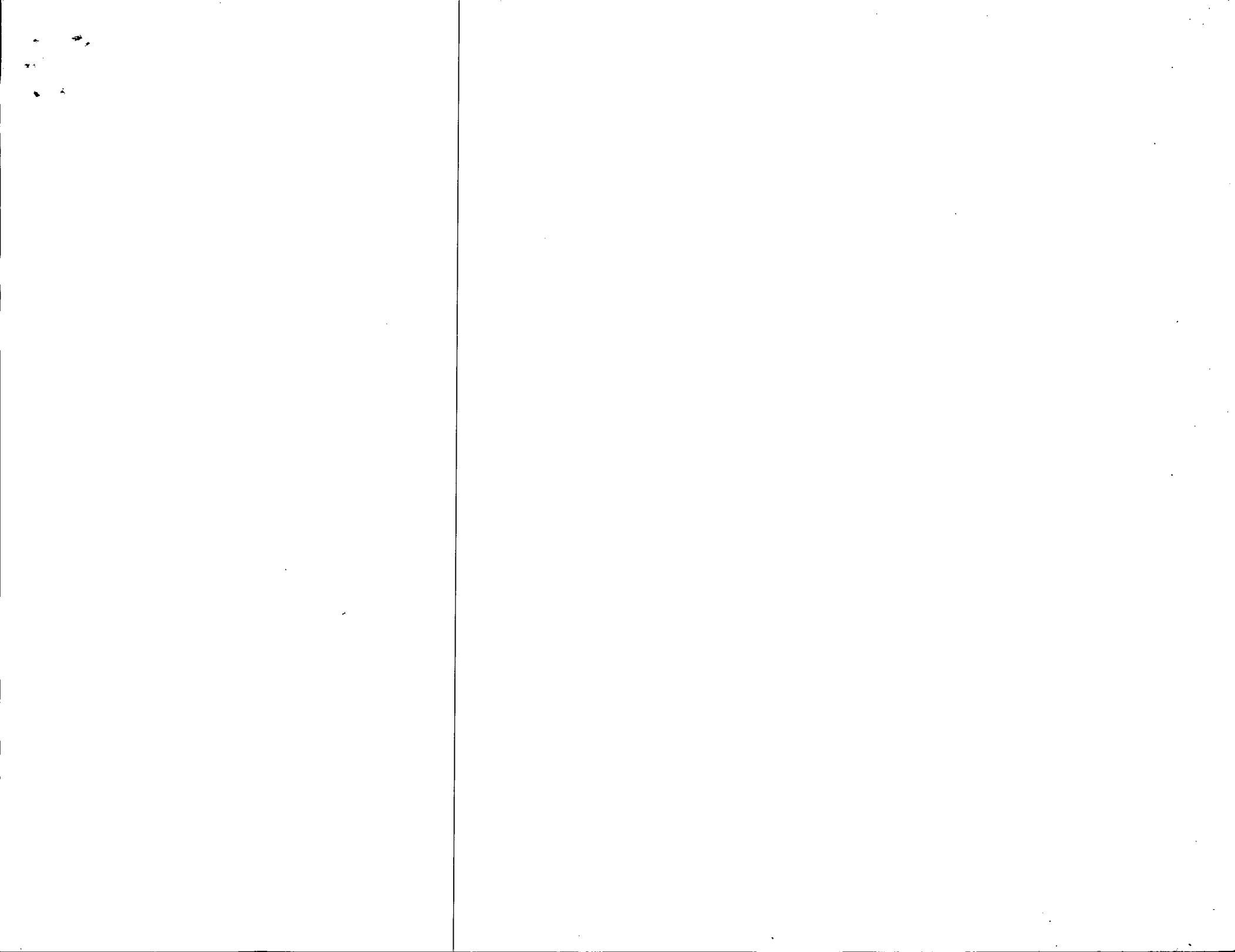
Comment: FINAL INSPECTION/W/O RELEASE

08/12/09

Job Completion



MF 08-12-08

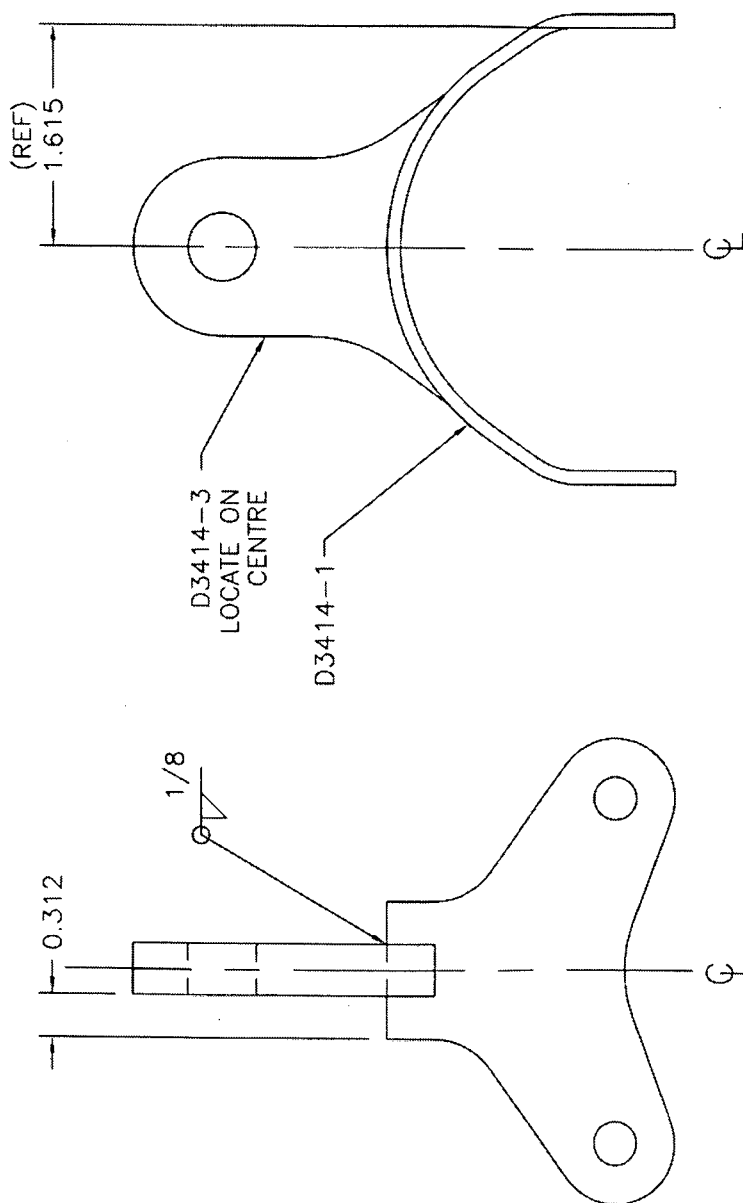


AC



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 1 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE NTS
A	05.03.16	NEW ISSUE	

05.03.16 *[Signature]*

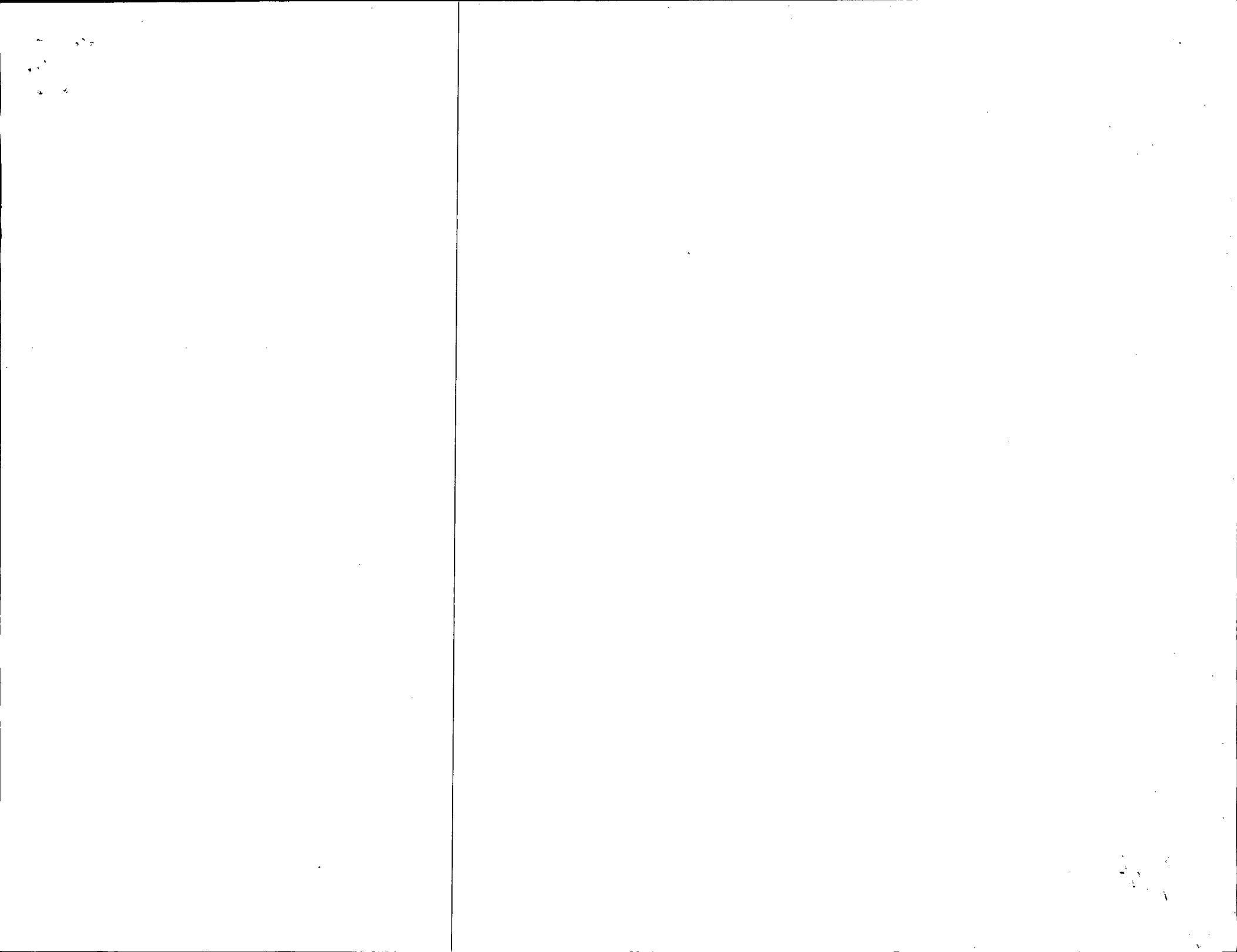


D3414-041 LUG ASSEMBLY

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRIC ABOUT CENTERLINE

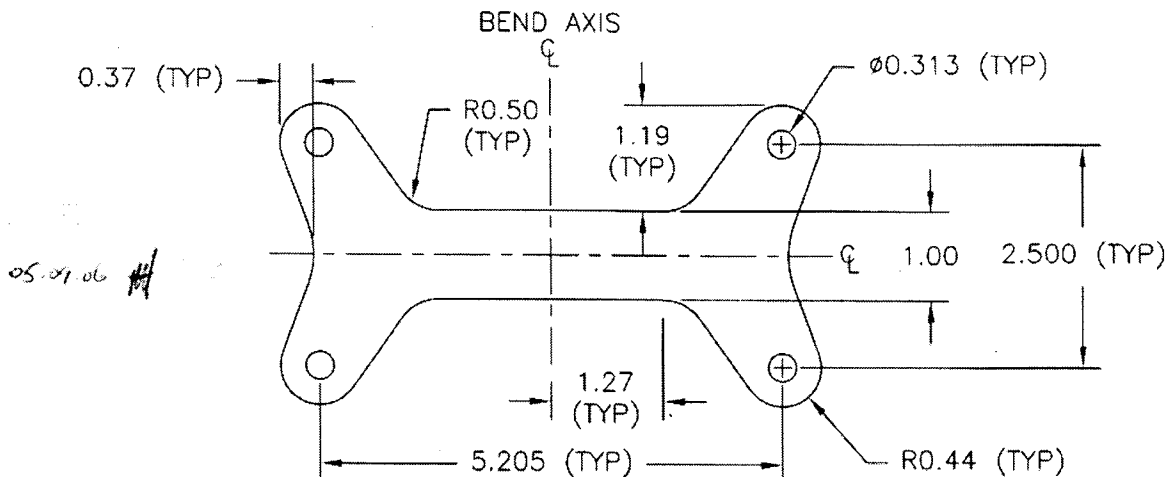
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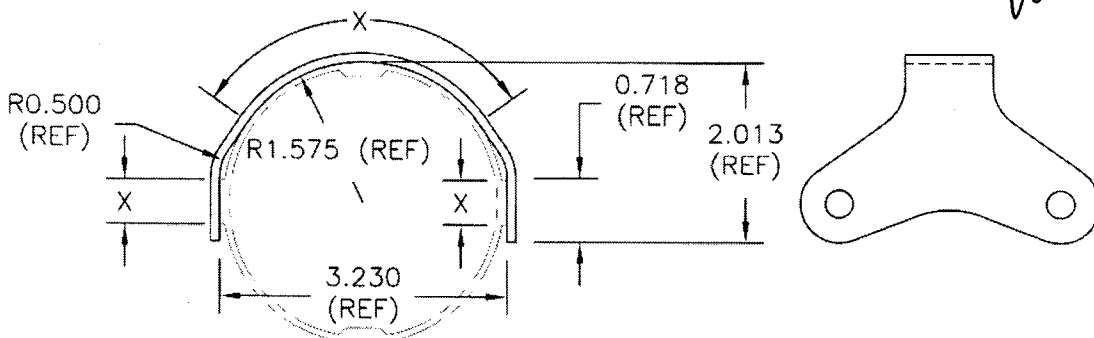


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3414	REV. A SHEET 2 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:2



D3414-1 FLAT PATTERN

SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D3414-1 BEND DETAIL

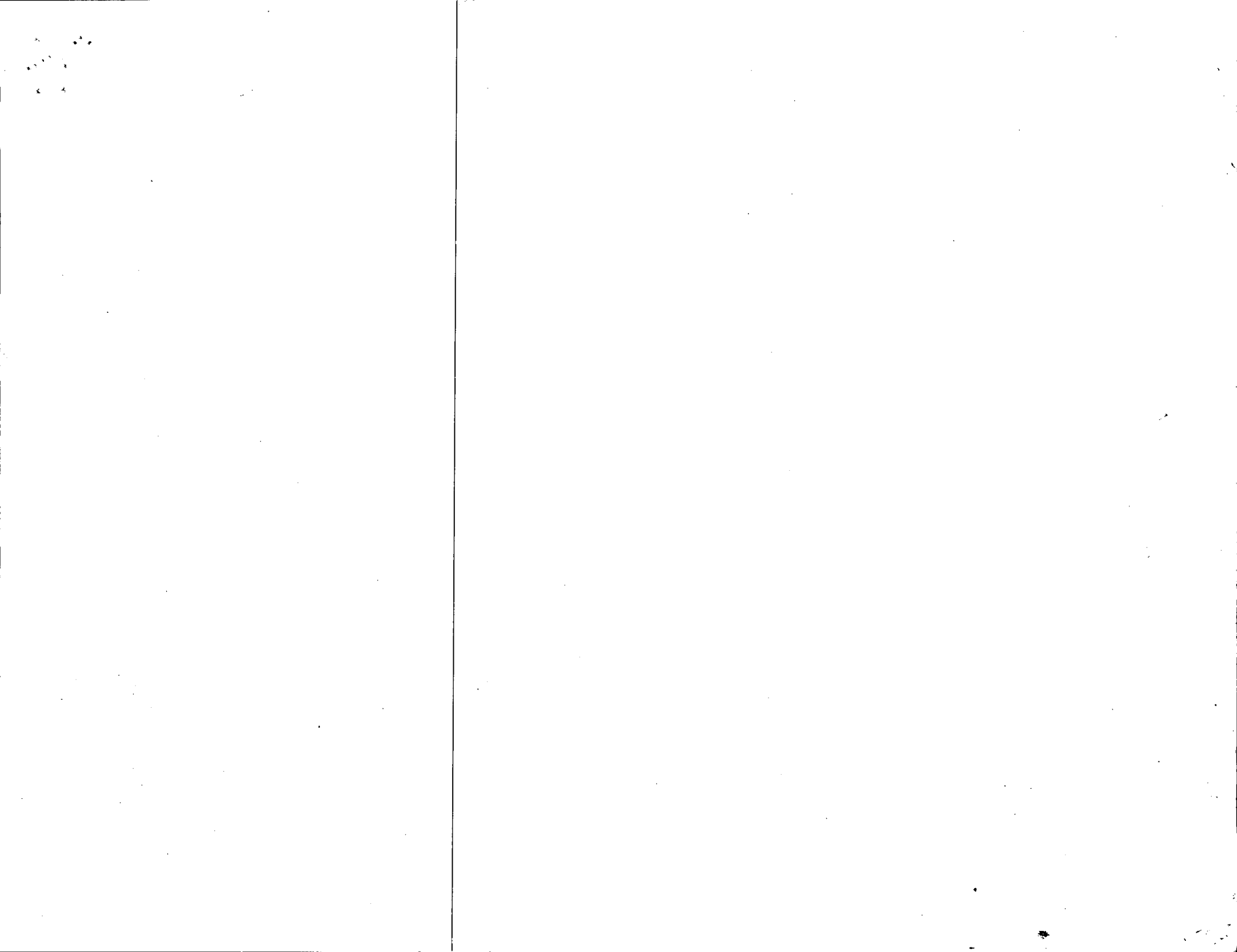
D3414-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3414-1 LUG BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 0.100 THICK (12 GAUGE, REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

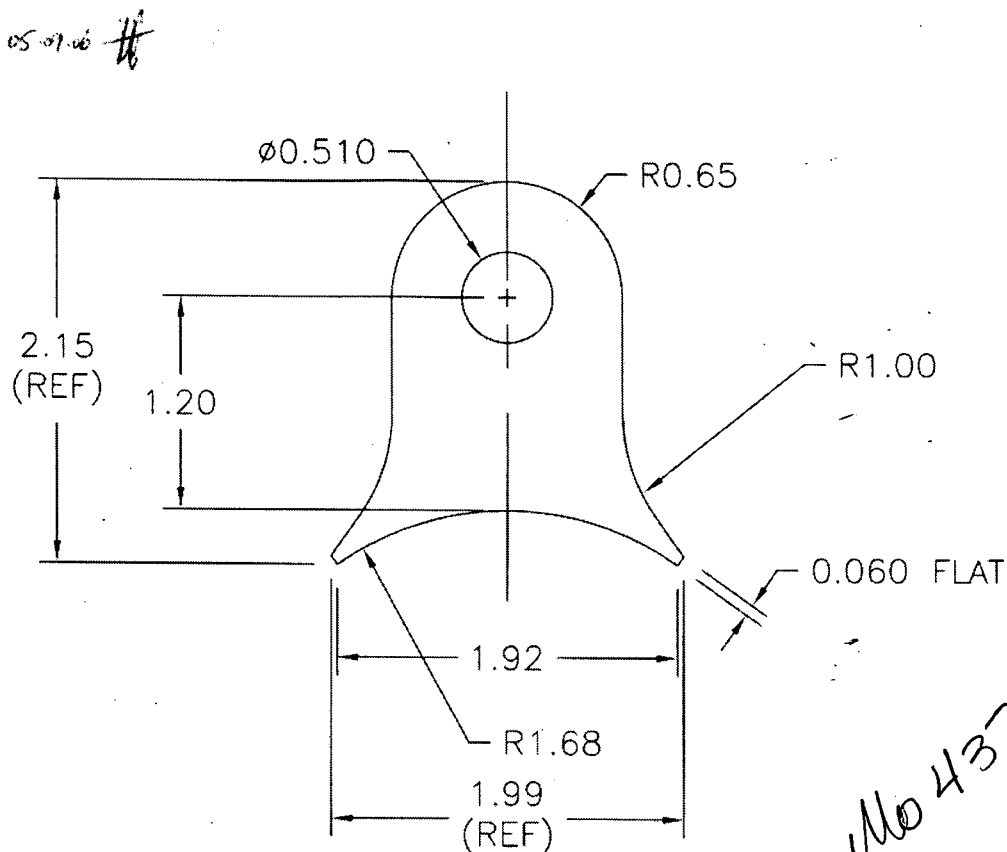
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CHECKED H	APPROVED H	DRAWING NO. D3414	REV. A SHEET 3 OF 3
DATE 05.03.16		TITLE LUG ASSEMBLY	SCALE 1:1



D3414-3 LUG

- 1) MATERIAL: AISI 304/316 SS PLATE 0.375 THICK (REF DART SPEC. M304S)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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